

Date: Monday, 12/01/2009 2:36:43 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : WEARPAD

Job Number : 44649-1

Estimate Number : 12712

P.O. Number :

Part Number : D35371

This Issue : 12/01/2009 S.O. No. :

Drawing Number : D3537 REV C

Prsht Rev. : NC

Project Number : N/A

First Issue : 11 Type : SMALL / MED FAB

Drawing Revision : C

Previous Run : 43346

Material :

Due Date : 26/01/2009

Qty: 60 Um: Each

Written By :

Checked & Approved By : JLD 09.01.13

Comment : Est Rev:A New Issue 07-02-14 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304S16GA

304/316 Sheet .063



Comment: Qty.: 0.1113 sf(s)/Unit Total: 6.6780 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: 110551 HB 9-1-26

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: S

Prog Rev: C

HB 9-1-26

2-Deburr if necessary

HB 9-1-26

(69)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



HB 9-1-26

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S 02/01/26 counter (68)

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

SB 09/01/27

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 44649

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R 2059B Hardcoat

M109893

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

BR 9-1-29

(X28)

7.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

509/01/29

(X28)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/01/29

counters

(X28)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M109648

START TIME:

13:40

OVEN TEMPERATURE:

320°

FINISH TIME:

14:10

BR 09-01-29

(28)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-29

(X28)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: EP-17

9H 09-01-29

28

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

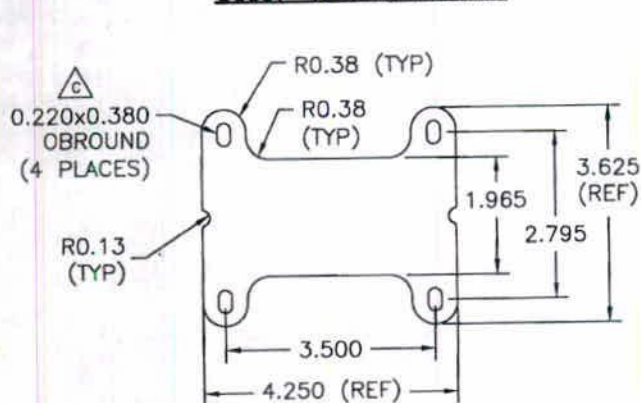
09/01/29

Job Completion

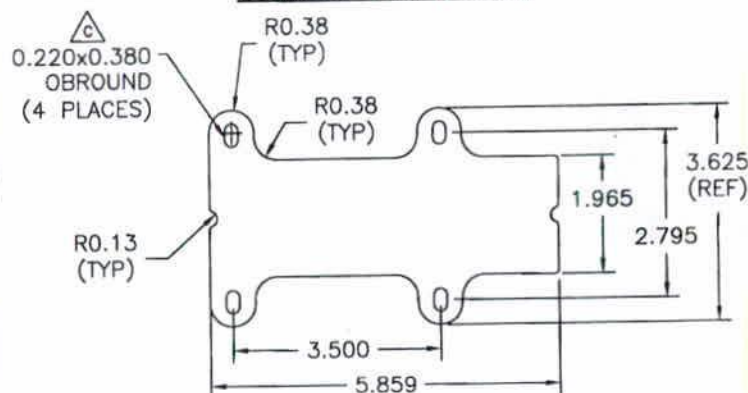


MF 09-01-29

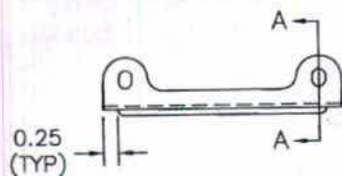
D3537-1F FLAT PATTERN



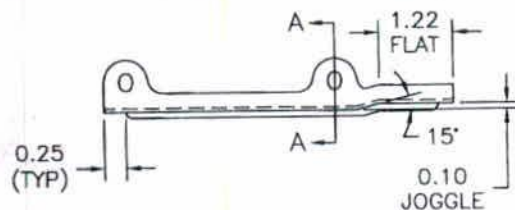
D3537-3F FLAT PATTERN



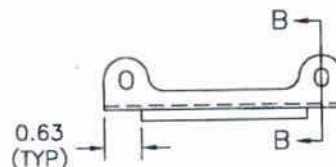
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

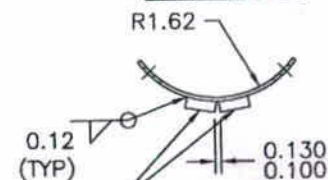


SECTION A-A



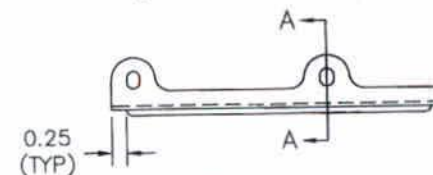
APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

SECTION B-B



D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY PH
CHECKED	4	APPROVED 4
DATE	07.04.13	DRAWING NO. D3537
		TITLE WEARPAD
		REV. C
		SHEET 1 OF 1
		SCALE 1:2

DART AEROSPACE USA, INC.
PORT HADLOCK, MA

RELEASED
07.05.08 PM
PCF ELN
962